

Work Order ID 59595

Tuesday, June 08, 2010 2:32:01 PM

Page 1

Item ID: D2648-3

Accept

Revision ID:

Item Name: Wearpad

Start Date: 6/8/2010 Start Qty: 30.00

Required Date: 6/21/2010 Req'd Qty: 30.00

Reference:

Approvals:

Process Plan: PHDate: 10-6-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2648

Rev D

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2648 ***** CUT WITH FILE D2648-

***** ☐ Dwg Rev: D ☐ Prog Rev: D☐

2-Deburr if necessary

10-6-21

(33)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-6-21

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

5/12/06/21count
(33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3								
150 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch A/R 560Hardcoat 113328 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary								

N/A

83 1206/23 (33)

EL 10-6-29 (x33)

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Item ID: D2648-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/8/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/06/30



QC

Memo

0.00

Quality Control

(33)

170

QC5- Inspect part completeness to step on W/O

0.00

S 10/06/30



QC

Memo

0.00

Quality Control

counted
(33)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:15

OVEN TEMPERATURE:

320° FINISH TIME:

9:45

33 BR 10-7-7.

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



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Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

u

10/02/09

33

q



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location:

FP.16

0.00

33

BR 10-7-7.



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

u

10/04/09

33

q

10-7-7

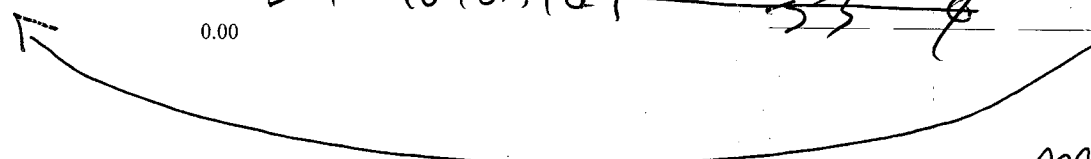


QC

Memo

0.00

Quality Control



MF 10-7-7

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Picklist Print

Tuesday, June 08, 2010 2:32:05 PM

Page 1

Work Order ID: 59595

Parent Item: D2648-3

Parent Item Name: Wearpad

Comments: IPP: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF
IPP Rev:F Now on Waterjet 06-08-14 JLM

Start Date: 6/8/2010

Required Date: 6/21/2010

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	89.0000	0.075	2.368421	2.475		
1010/1025 sheet 16GA													

Location

Loc Qty

Loc Code

MAT19

89

111410

89

111410

33

B10-6-21

W/O:		WORK ORDER CHANGES						
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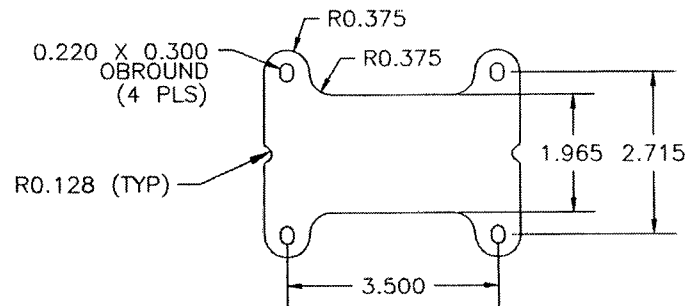
NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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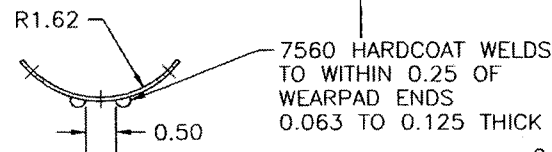
S. 11
RETURN

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59595
88106-06

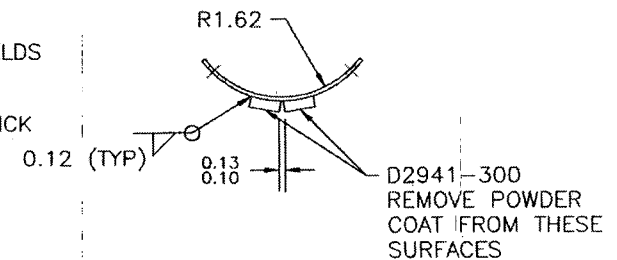
D2648-1 FLAT PATTERN



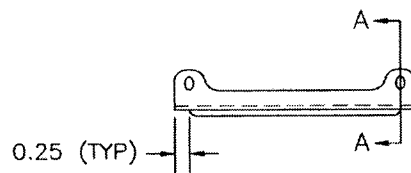
SECTION A-A



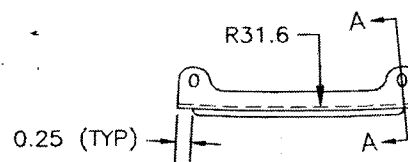
SECTION B-B



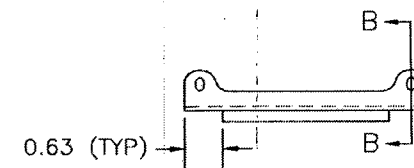
D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
14.12.20 15



D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BOLLEAUE, VA
CHECKED	APPROVED	DRAWING NO. D2648
DATE	99.11.17	TITLE WEARPAD
		REV. D SHEET 1 OF 1 SCALE 1:2

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